

Date: Friday, 12/12/2008 7:40:38 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SEAT RAIL
 Job Number : 44028
 Estimate Number : 13546
 P.O. Number :
 This Issue : 12/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D38111
 Drawing Number : D3811 REV A
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 41119 Material :
 Written By : 08.12.12 Due Date : 19/12/2008 Qty: 10 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-07-31 JLM Verified By:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X02500 6061-T6 Bar 1.50 x 2.50



Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s)

6061-T6 Bar 2.500x 1.50

Batch: M60716

JL 08/12/14

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 23.250 " long

JL 08/12/14

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA776Rev: AA & Dwg D3811 Rev: A

2-Deburr per dwg D3808.

JLP 08/12/16

(10)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLP 08/12/16

(10)

5.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-DRILL REMAINIG HOLES

ML 08/12/20

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

User: Jean-Luc Menard

Process Sheet

Customer: OGDAROM Part Helicopters Services

Drawing Name: SEAT RAIL

Job Number: 44028

Part Number: D38111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 08/12/20

(10)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08.12.20

(10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 08/12/22

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST63.

SS 08/12/22 x2

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22

Job Completion



W 08.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

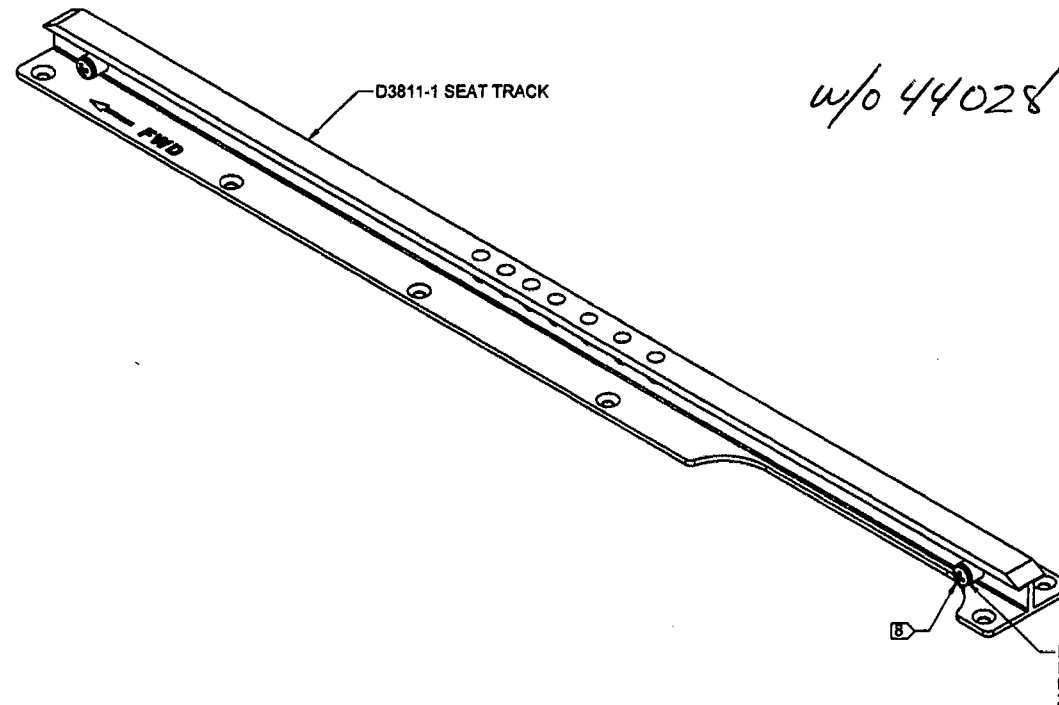
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



D3811-041 SEAT TRACK ASSEMBLY

RELEASED
08-03-2018

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

A	NEW ISSUE	RF	08.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3811** REV. A
SHEET 1 OF 3
TITLE **SEAT TRACK ASSEMBLY** SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

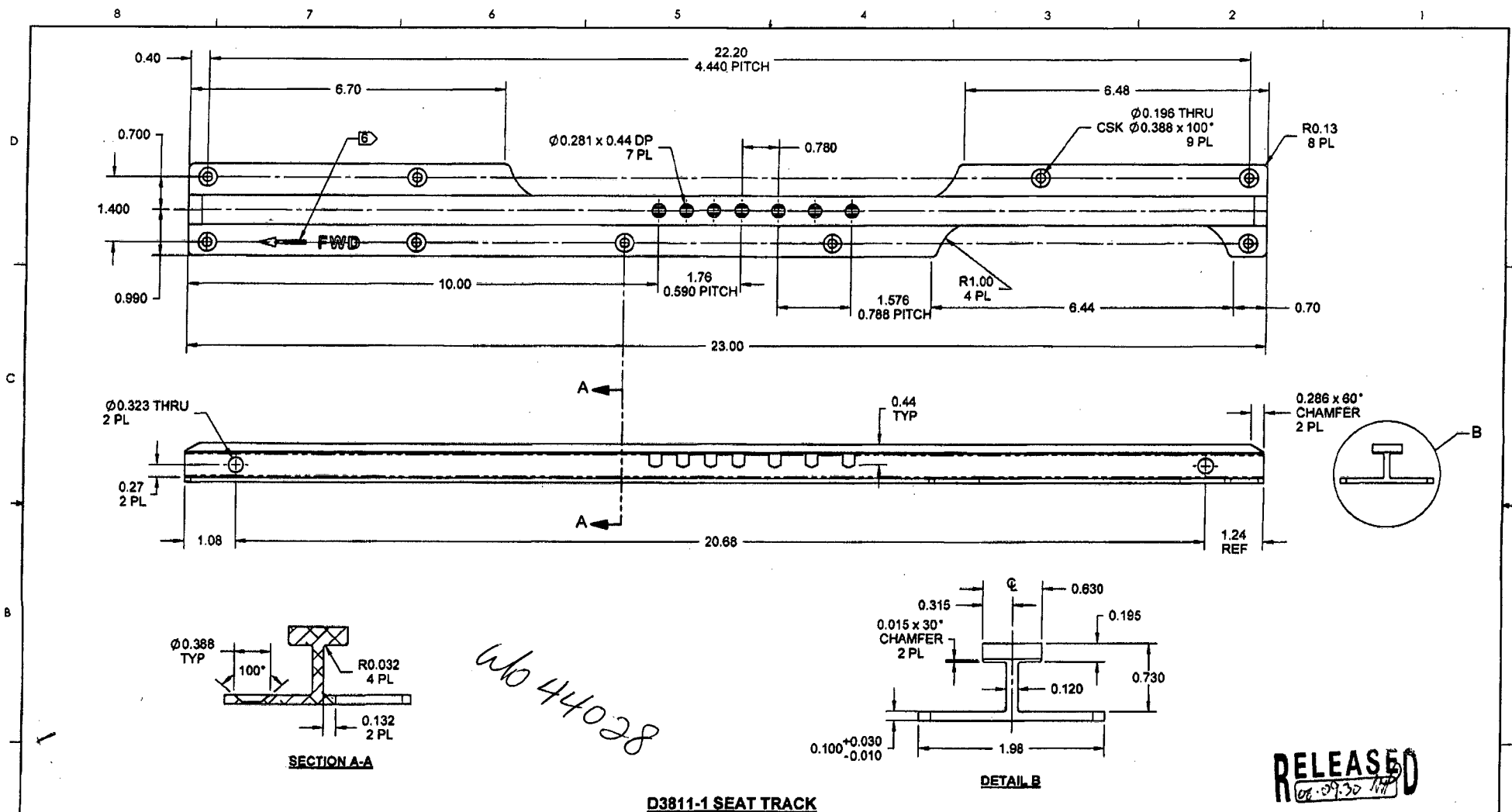
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




NOTE: Date & initial all entries



D3811-1 SEAT TRACK

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4180) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.25 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.724 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
DATE	08.08.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
08.09.30 1/18

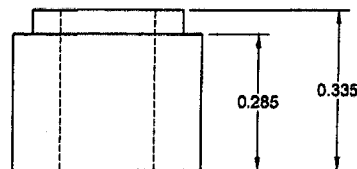
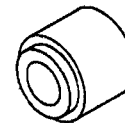
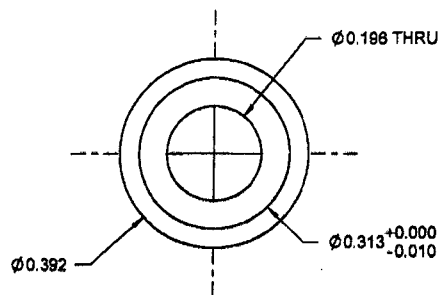
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3811-3 BUSHING

Wb 44028

RELEASED
68-09-30/16

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
DATE	08.08.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44028
Description: Seat Rail		Part Number: D3811-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.20	± 0.030	22.20	✓			
0.40	± 0.030	0.399	✓			
6.70	± 0.030	6.700	✓			
6.48	± 0.030	6.480	✓			
Ø 0.281	$+0.006/-0.001$	0.284	✓			(7 Places)
0.44 Deep	± 0.030	0.445	✓			(7 Places)
0.780	± 0.010	0.780	✓			
Ø 0.196	$+0.005/-0.001$	0.199	✓			
CSK Ø 0.388 X 100°	$\pm 0.010 / \pm 1/2^\circ$	0.395 / 100°	✓			(9 Places)
R0.13	± 0.030	0.130	✓			
0.700	± 0.010	0.700	✓			(8 Places)
1.400	± 0.010	1.400	✓			
0.990	± 0.010	0.990	✓			
10.00	± 0.030	10.002	✓			
1.76	± 0.030	1.766	✓			
1.576	± 0.010	1.576	✓			
R1.00	± 0.030	1.000	✓			(4 Places)
6.44	± 0.030	6.440	✓			
0.70	± 0.030	0.700	✓			
23.00	± 0.030	22.996	✓			
1.08	± 0.030	1.076	—			
1.24	± 0.030	1.240	—			
.27	± 0.030	.268	—			

Measured by: DJP/mk	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/12/16	Date: 12-12-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 44028
Description: Seat Rail		Part Number: D3811-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.323	+0.006/-0.001					(2 Places)
0.27	± 0.030					
1.08	± 0.030					
20.68	± 0.030					
0.286 X 60°	± 0.010 / ± 1/2°	0.290 X 60°	✓			(2 Places)
1.24	± 0.030					(REF)
R0.032	± 0.06	0.032	✓			(4 Places)
0.132	± 0.010	0.131	✓			(2 Places)
0.630	± 0.010	0.628	✓			
0.315	± 0.010	0.315	✓			
0.015 X 30°	± 0.010 / ± 1/2°	0.020 X 30°	✓			(2 Places)
0.195	± 0.010	0.192	✓			
0.120	± 0.010	0.120	✓			
0.730	± 0.010	0.732	✓			
0.100	+0.030/-0.010	0.102	✓			
1.98	± 0.030	1.979	✓			

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/12/16	Date: 02.12.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	